

# Work Order ID 64619

December 9, 2010 10:38:03 AM



Page 1

Item ID: D4094-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/09/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/24/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

*W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4094	A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 2.125" Long

*and 10/12/20*

*6*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per dwg anf Folio FA923

FOLIO REV: *AA*

DWG REV: *A*

*and 10/12/21*

*6*

Deburr & Engrave as per Dwg

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Item ID: D4094-1

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Start Date: 12/09/10 Start Qty: 6.00

Cust Item ID:

Required Date: 12/24/10 Req'd Qty: 6.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		SL 10/12/21		6	8		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		SL 10/12/21		6			
140  Packaging Packaging	Identify as per dwg & Stock Location: 125  Memo ***IDENTIFY PART WITH ERA P/N AS PER NOTE 6 ON DWG D4094***	0.00 0.00							12/4/22 (6)

**Work Order ID 64619**

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Item ID: D4094-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/09/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/24/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/22

P/10-2-2.2  
(6)

# Picklist Print

December 9, 2010 10:38:02 AM

Page 1

Work Order ID: 64619



Parent Item: D4094-1



Parent Item Name: Bracket

Start Date: 12/09/10

Required Date: 12/24/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:DD IPP  
Rev:B 10.05.27 as per ECN10-548 DD verf:EC IPP Rev:C  
10.06.11 added comment in seq140 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased			No	100	f	14.0790	0.18	1.136842			

303 BAR 2" X 1.750"

Location

Loc Qty

Loc Code

MAT

13.76646

115047

13.76646

MAT53

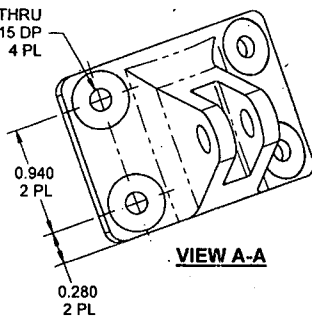
0.31251

→ 113310

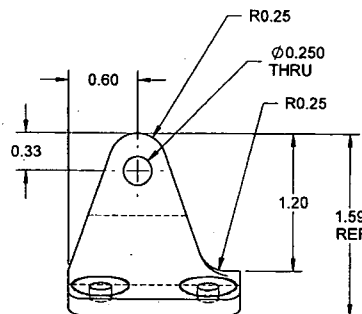
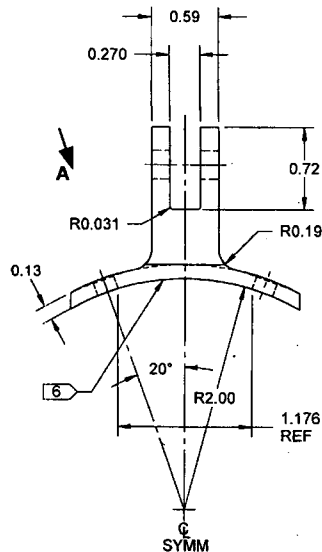
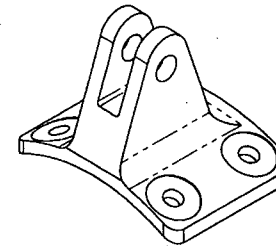
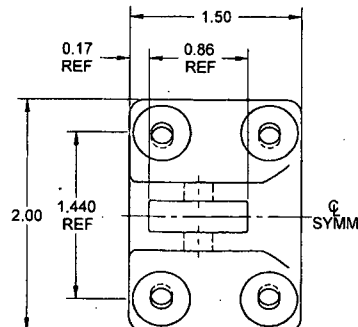
0.31251

1.137 *ml 10/12/20*

Ø0.189 THRU  
CBORE Ø0.50 X 0.015 DP  
4 PL



VIEW A-A



D4094-1 BRACKET

26 64619

RELEASE  
2010-05-20

NOTES:

- 1) MATERIAL: AISI 303 BAR PER ASTM A582  
REF. DART SPEC. M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ERA P/N "41232-200-006-901" USING VIBRATING STYLUS
- 7) WEIGHT: 0.23 lbs

REV.	NEW ISSUE	DESCRIPTION	MB	10.04.07
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.04.07			

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

DRAWING NO. D4094  
REV. A  
SHEET 1 OF 1  
TITLE BRACKET  
SCALE NTS

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DART AEROSPACE LTD		Work Order: 64619
Description: BRACKET		Part Number: D4094-1
Inspection Dwg: D4094 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.189	+ .005 - .001	Ø.191	—		Vern	ML-7
Ø.50	± .030	Ø.502	—		"	"
.015	± .010	.017	—		"	"
.940	± .010	.938	—		"	"
.280	± .010	.280	—		"	"
.59	± .030	.590	—		"	"
.270	± .010	.271	—		"	"
.72	± .030	.716	—		"	"
R.19	± .030	R.190	—		Rad-gage	REF
.13	± .030	.135	—		Vern	ML-7
.33	± .030	.328	—		"	"
.60	± .030	.605	—		High-gage	31006
R.25	± .030	R.250	—		Rad-gage	REF
Ø.250	+ .005 - .001	Ø.251	—		Vern	ML-7
R.25	± .030	R.250	—		Rad-gage	REF
1.20	± .030	1.210	—		High-gage	31006
1.59	± .030	1.604	—		"	"
2.00	± .030	2.004	—		Vern	ML-7
1.50	± .030	1.501	—		"	"

Measured by: <i>Am</i>	Audited by: <i>SL</i>	Prototype Approval:	N/A
Date: 10/12/21	Date: 10/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	